

5/44

DART AEROSPACE	Work Order:	244503
Description: Bearpaw Clamp	Part Number:	D2882
Drawing: D2882 Rev.A D2727 Rev.A1	Qty:	202

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	FF	05.10.12	200
2	PURCHASING	Issue P/O: 2008807 Laser cut as per Dwg D2882 Mat'l AISI 304/316 SS .75 wide x .063 thick. Material release note required	DL	05-10-12	200
3	RECEIVING	Receive and inspect for transit damage Ensure material release note attached	CL	05/11/08	202
4	QC	Inspect Level 6 (6.974 end to end" 6.174 center to center)	Z	05-11-14	202
5	METAL	Tumble & Deburr any rough edges after tumbling	DL	05/11/15	202
6	METAL	Form as per Dwg D2882 Use brake to form ends. Finish form using DT8295	DL	05/11/29	202
7A	QC	Inspect Level 5	Z	05-11-29	202
7B	GA	Tumble	FF	05.12.05	202
8	STORES	Identify and Stock	L	5/12/06	202
9	EXPEDITING	Close W/O Cost / Part: 5.44 05/12/08 Inspect level 2	DL	05/12/07	202

Rev	Date	Change	Revised By	Approved
A	00.01.14	New issue	EC	
B	02.01.17	Added laser cutting.	NG/EC	<i>[Signature]</i>

RELEASED

02/01/17 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

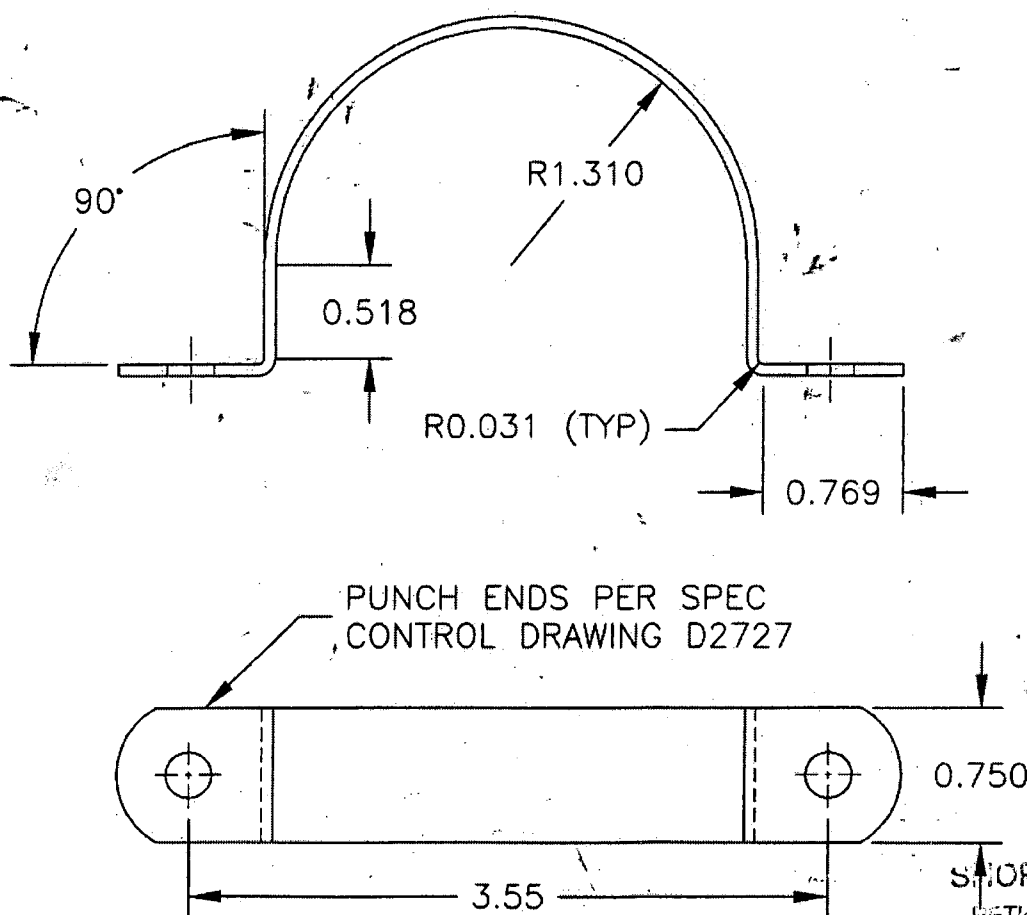
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/12/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>QA</i>	DRAWING NO. D2882	REV. A SHEET 1 OF 1
DATE 99.03.19		TITLE CLAMP	SCALE 1:1
A	99.03.19	NEW ISSUE	

RELEASED
99.04.12 KE

FLAT LENGTH: 6.974 END-END
6.174 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.75 WIDE x 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

24505

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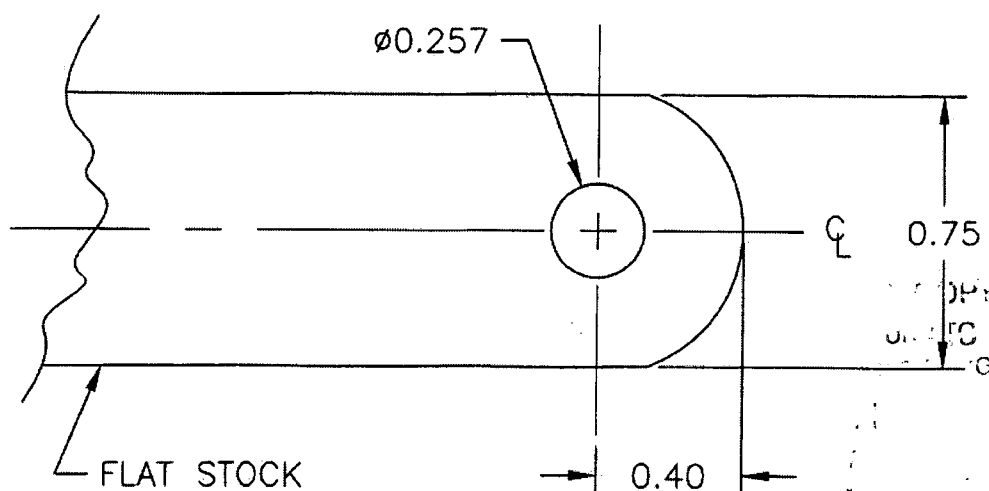
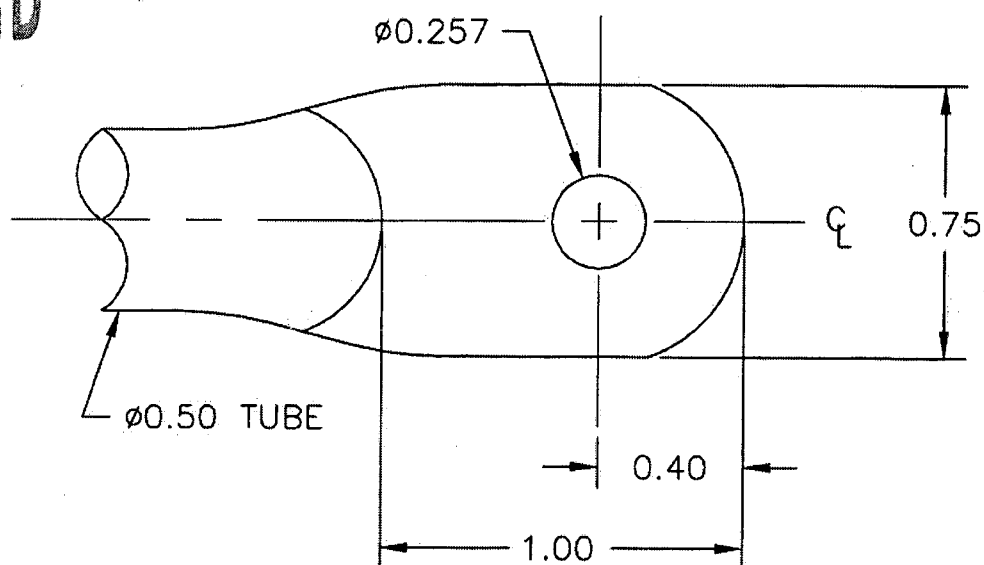
АВИАПРОСТА



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MAY	APPROVED CA	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#CP 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

IN ORDER

NO. 24505

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Honorable Member,
Mr. and Mrs.
Budd, etc.,
My dear Sir,

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ALL INFORMATION CONTAINED
HEREIN IS UNCLASSIFIED
DATE 11-17-2010 BY 60322
UCBAW/STP

Date: Thursday, 11/17/2005 12:10:39 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW CLAMP
Job Number	: 24505		
Estimate Number	: 10622		
P.O. Number	:	Part Number	: D2882
This Issue	: 11/17/2005 S.O. No. :	Drawing Number	: D2882 REV A
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: _____	Due Date	: 11/24/2005 Qty: 200 Um: Each
Checked & Approved By	: _____		
Comment	: Est. B 02.01.17 Added laser cutting. NG/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: _____

Laser cut as per Dwg D2882

Mat'l AISI 304/316 SS .75 wide x .063 thick.

Material release note required

2.0	D2882B	Clamp
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3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

(6.974 end to end" 6.174 center to center)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr any rough edges after tumbling

Form as per Dwg D2882 Use brake to form ends.

Finish form using DT8295

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:21 pm

Work Order No : 0024505
Project Name : D2882
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2882
Description : Clamp
Manufactured : Yes
Amount Req'd : 200
Amount Done : 0
Start Date : 10-08-05
Est Finish Date : 11-07-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00